

Split

Work Order ID 138874-2

138874

Page 1

Friday, November 13, 2015 11:35:30 AM

Item ID: D2282-043

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle Assembly

Start Date: 11/13/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Run

Start

NR1

Approvals:

Process Plan: MLS

Date: NOV 16 2015

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2282	Rev E								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Weld as per D2282-043 Saddle Assembly								
	A/RER316L SS Filling Rod M/260/4								
	Dwg Rev: E								
110	Small Fab	0.00							
110									
Small Fab	Memo	0.00							
Small Fab	1- Grind weld with rough pad and brown pad, take all welding marks out and								
	debur holes***DO NOT TAKE RED AND BLUE PAD TO BUFF PART***								
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

x18 MR. 15-12-07

x18 MR. 15-12-10

(18) 15-12-11. DAS
9
9-89

Work Order ID 138874

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Page 2

Item ID: D2282-043

Accept

N9000040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle Assembly

Start Date: 11/13/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Run

Start

NR1

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Memo

1 -Tumble

0.00

150

150

QC

Memo

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
30
9-89

9

DEC 15 2015

160

160

Packaging

Memo

LOCATION : GA

0.00

0.00

DAS
30
9-89

9

DEC 15 2015

Identify as per dwg & Stock Location: GA

Work Order ID 138874

138874

Page 3

Friday, November 13, 2015 11:35:30 AM

Item ID: D2282-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle Assembly

Start Date: 11/13/2015 Start Qty: 5.00

5

Cust Item ID:

Required Date: 11/13/2015 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

ML5

DEC 15 2015

ML5

DEC 15 2015

Picklist Print

Page 1

Friday, November 13, 2015 11:35:29 AM

Work Order ID: 138874

138874

Parent Item: D2282-043

D2282-043

Parent Item Name: Saddle Assembly

Start Date: 11/13/2015

Required Date: 11/13/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A Removed from 9 Digit 05-12-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2281		Manufactured	No			100	Each	0.0000	1	8			
D2281									**	x 18		MR	15-12-07
Jack Saddle													
D2282-7		Manufactured	No			100	Each	36.0000	2	10			
D2282-7									**	x 36		MR	15-12-07
Tube													

Location

Loc Qty

Loc Code

WA001

36

137241

36

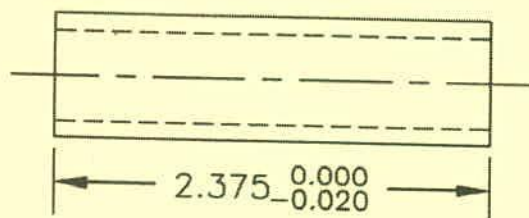
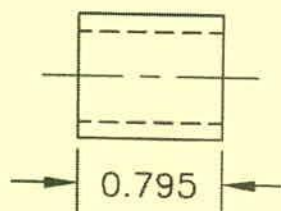
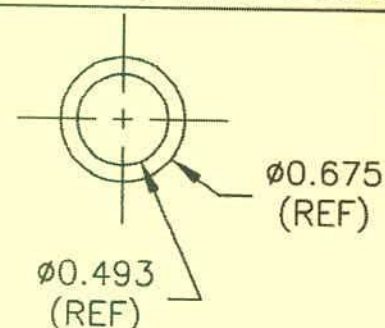
x 36

DART

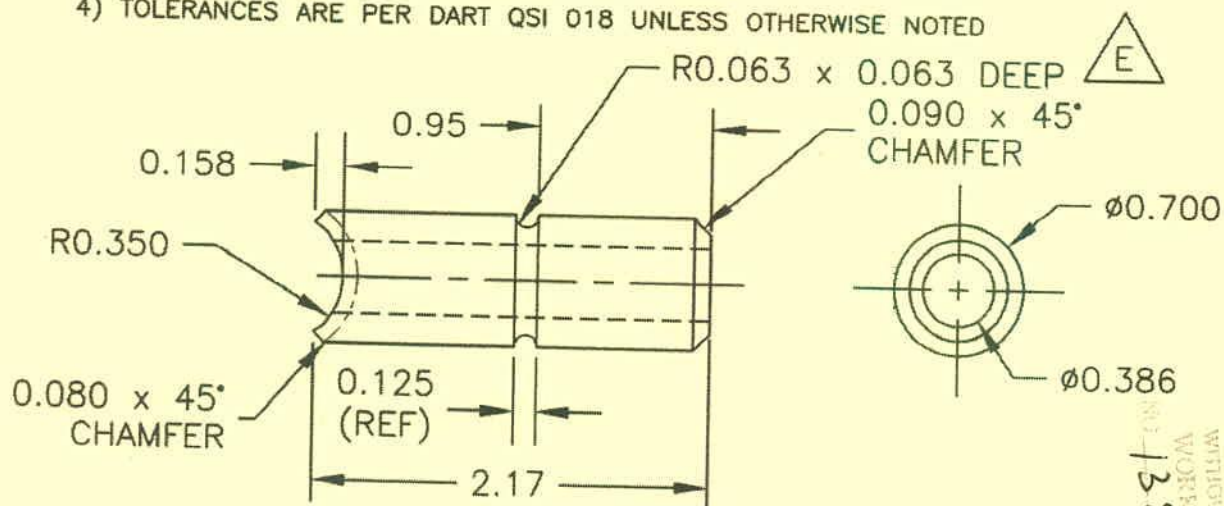
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

RELEASED

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
138834
15-11-16

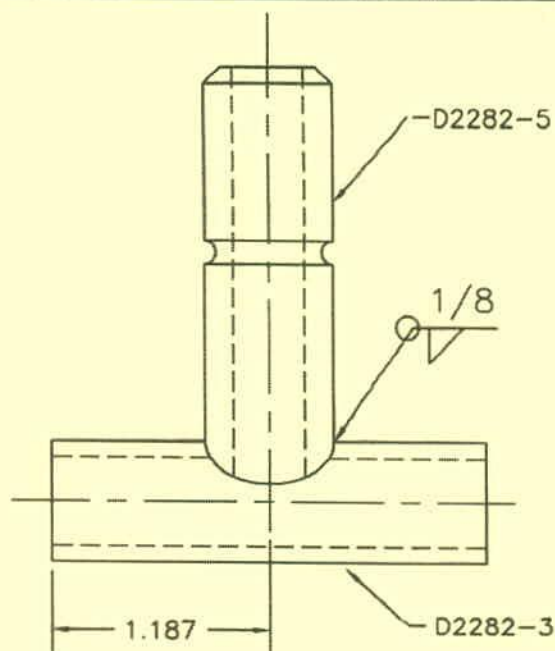
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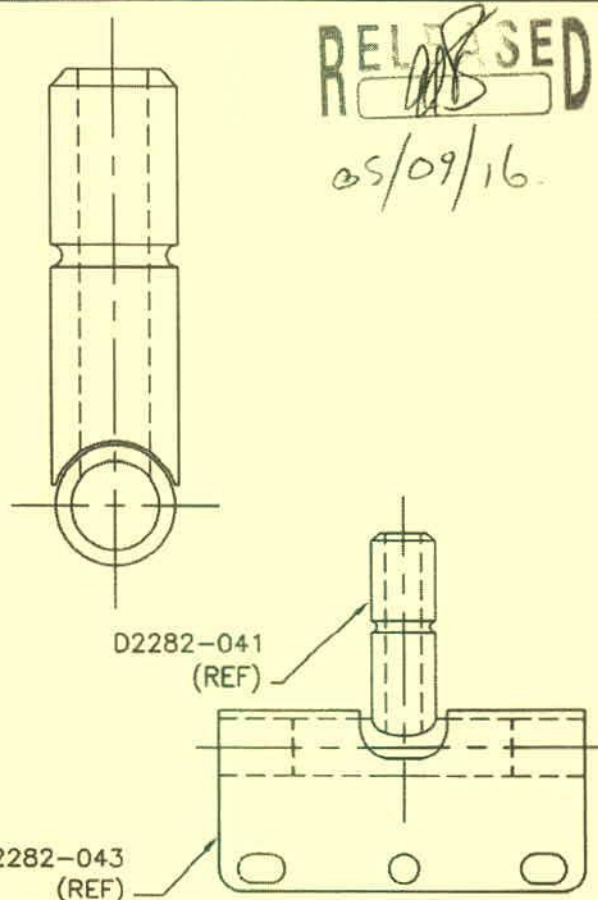
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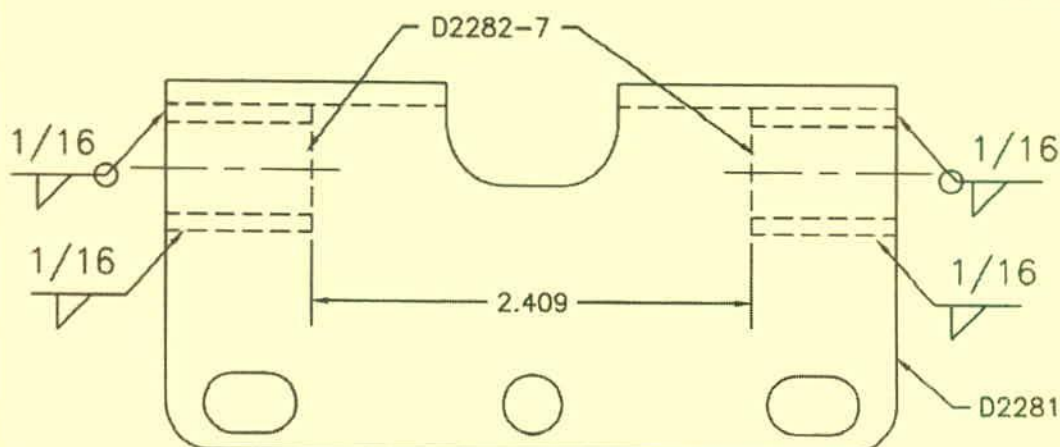
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CHECKED <i>UP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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